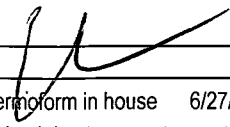
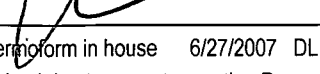


Date: Wednesday, 03/10/2007 7:13:03 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : A119 BUBBLE WINDOW
Job Number : 34996	
Estimate Number : 12911	
P.O. Number :	Part Number : D36242
This Issue : 03/10/2007 S.O. No. :	Drawing Number : D3624 UNDER REVIEW <i>OK 07.10.03</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : THERMOFORMING	Drawing Revision : REV. C
Previous Run : 34432A	Material :
Written By : 	Due Date : 10/10/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est. A Thermoform in house 6/27/2007 DL Est B. Revised due to corrupt operating Program. 7/23/2007 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MACRYLIC177	0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SH



Comment: Qty.: 10.0000 sf(s)/Unit Total: 10.0000 sf(s)
 0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SH

1) Batch # *M 105075*

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks to 30" by 48"

DL 07.10.03

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3624 and Folio FTA 004

Dwg. Rev. *C*Folio Rev. *D**DL 07.10.03*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check depth of bubble to ensure conformity to drawing tolerances.

DL 07.10.03

Date: Wednesday, 03/10/2007 7:13:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 BUBBLE WINDOW

Job Number: 34996

Part Number: D36242

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

oh 07.10.03

6.0

QC2

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

oh 07.10.03

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

W/A.

STRUCTURAL TESTING.

PTO →

1) Sand and Polish out any mould marks and/or blemishes

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1) Visually inspect for clarity, and proper formation.

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 2008/3/17 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.10.03	7	Part used for structural testing.	Ph	07.10.03			

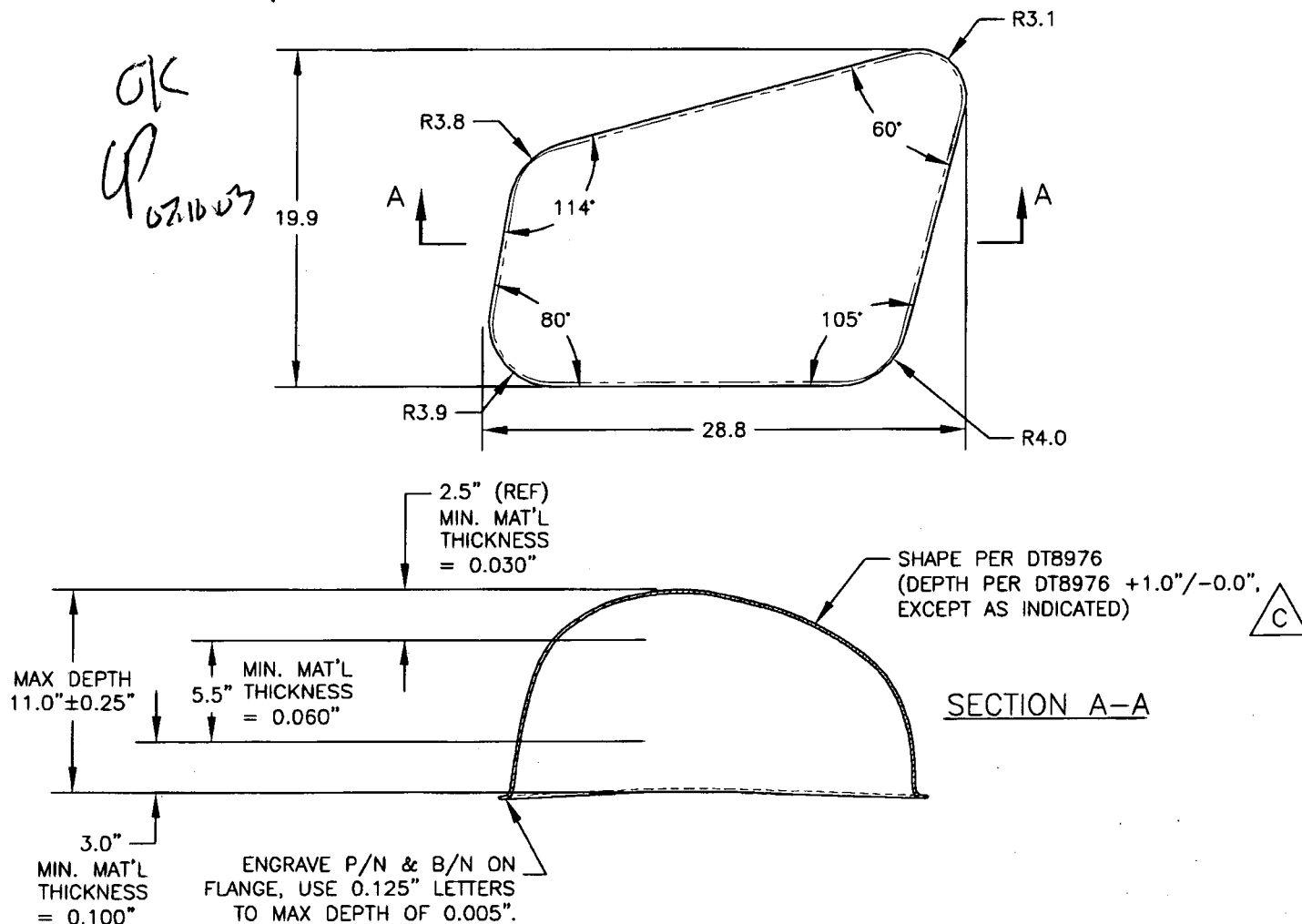
Part No: D3624-2 PAR #: N/A Fault Category: Prod / Interfering NCR: (Yes) No DQA: 10 Date: 08/03/19
 QA: N/C Closed: 10 Date: 08/03/19

NCR: 34956		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.03	7	Unit did not pass testing	Ph	Scrap part and close W.O. wait for direction from Engineering.	Ph 07.10.04	Ph 06.05.17	Ph	Ph

NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3624	REV. C SHEET 1 OF 1
DATE 07.06.27		TITLE BUBBLE WINDOW (A119)	SCALE 1:10
A	07.05.14	NEW ISSUE	
B	07.05.24	11.0" DEPTH WAS 12.0"	
C	07.06.27	ADD TOOL TO CONTROL BUBBLE SHAPE	

RELEASED
07.06.28 *#***D3624-2 BUBBLE WINDOW**

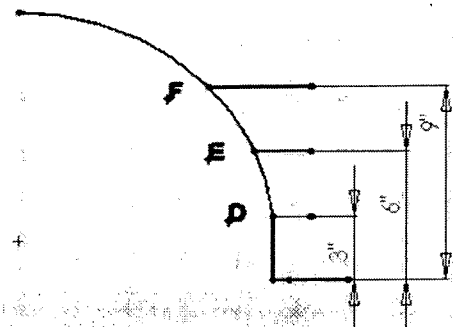
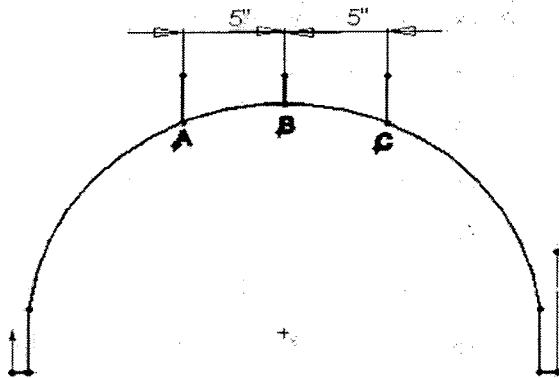
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC OR PLEXIGLAS "G" CAST ACRYLIC, 0.177" THICK
(REF DART SPEC. M-ACRYLIC-S.177)
- 2) FORM PER DT8953
FORMING PROCESS:
 - (a) DRAPE MAT'L OVER DT8953 MOLD
 - (b) HEAT TO 286°F
 - (c) VACUUM TO SPECIFIED HEIGHT
 - (d) LEAVE FOR AT 2 MINUTES TO COOL
 - (e) TRIM WINDOW PER DT8954
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

D3624-2 DIM SHEET



		TEST FLIGHT(REF)	RETURN (REF)
A	.065	0.051	0.078
B	.057	0.034	0.058
C	.063	0.038	0.039
D	.091	0.095	0.06
E	.073	0.082	0.052
F	.066	0.065	0.059

Date: Wednesday, 23/04/2008 1:12:05 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 34996	Customer	: Dart Helicopters Services
Estimate Number	: 12911	DWG Name	: A119 BUBBLE WINDOW
Purchase Order #	:	Part Number	: D36242
Complete Date	: 17/03/2008 2:02:41	DWG Number	: D3624 UNDER REVIEW
		Rev.	: REV. C

DUE DATE	ORDERED	DELIVERED
10/10/2007	1	0

1.0 MACRYLICS177-0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SH

DATE	EMPLOYEE	TYPE	Qty	COST	
27/02/2008	LACE01: Lacelle, Linda	MACRYLICS177	10.000	\$56.57	Lot # 105075 Qty. 10

Subtotal:	QTD:	0	CTD:	10	\$56.57
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	TIME	COST
Machine Time:	0.00	\$0.00
Labor:	0.00	\$0.00
Sub-contract (external Op.):		\$0.00
INVENTORY ITEM:		\$56.57
SUB-COMPONENT (SUB-JOB):		\$0.00
Total:		\$56.57

COST PER UNIT:	\$56.57
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